

Amendments to the Claims

This listing of claims will replace all prior versions, and listing, of claims in the application.

Listing of Claims:

Claims 1-10. (CANCELED)

11. (Currently amended). A shank-end tool for the use for milling-type machining of chipless materials for the manufacture of molds in the sand casting industry, especially heat-resistant foundry sand casting molds for producing metal castings, said tool comprising:

a shank portion having a longitudinal axis, a first end that can be connected detachably to a drive device and a second end with a groove-shaped recess extending in the longitudinal direction; and

a ~~cutter~~ blade as an insert tool in the form of a flat bar having a thickness from 0.1 mm to 5.00 mm in said groove and fixedly attached to the shank, said ~~cutter~~ blade having a flat leading face in a direction of advance during use, ~~wherein the cutter blade in the form of a flat bar has a~~ leading blade edge with at least a portion of the leading edge substantially parallel to said longitudinal axis and the flat bar is provided without cutting edges on the leading face,

wherein the ~~cutter~~ blade is a flat blank of a material selected from the group consisting of steel, wear-resistant steel, or a wear-resistant material, and wherein said leading blade edge is at a right angle to the flat leading face.

12. (Currently amended). A shank-end tool in accord with Claim 11, wherein the flat leading face of the ~~cutter~~ blade is more wear resistant than ~~then~~ the rear side of the cutter blade, wherein the ~~cutter~~ blade comprises a steel base material and is provided with a wear - protective covering on the leading flat face, the wear-protective covering being a material selected from the group consisting of a hard substance, a metal composite containing hard substances, and a metal alloy containing a hard substance.

13. (Currently amended). A shank-end tool in accord with Claim 11, ~~cut~~blade further comprising a trailing edge behind the blade edge when viewed in the direction of advance, wherein the leading blade edge and the trailing edge are rounded.

14. (Currently amended). A shank-end tool in accord with Claim 11, wherein the flat leading face of the ~~cut~~blade has a rounded corner or a corner cut at an angle.

15. (Currently amended). A shank-end tool in accord with Claim 11, wherein the flat leading face of the ~~cut~~blade has an outer contour with a circular arc or conical shape.

16. (Currently amended). A shank-end tool in accord with Claim 11, the ~~cut~~blade further comprises a curved surface having a convex face or a bent surface, parallel to the longitudinal axis, with the convex face of the curved surface or of the bend pointing in a direction of rotation of the shank in use.

17. (Currently amended). A shank-end tool in accord with Claim 11, wherein the ~~cut~~blade further comprises shovel-like blade folds that are sloped with a blade angle relative to the longitudinal axis to produce fan-like action.

18. (Currently amended). A shank-end tool in accord with Claim 11, wherein the ~~cut~~blade comprises a material selected from the group consisting of a metal, a high-strength elastically deformable material, and a springy material.

19. (Canceled).

20. (Previously presented). A shank-end tool in accord with Claim 11, wherein the shank comprises a tubular or cylindrical hollow body at least at the second end.

21. (Currently amended). A method for the milling-type machining of chipless materials for the manufacture of heat-resistant sand molds, said method comprising:

providing a shank-end tool comprising:

a shank portion having a longitudinal axis, a first end that can be connected detachably to a drive device and a second end with a groove-shaped recess extending in the longitudinal direction; and

a ~~cutter~~ blade as an insert tool in the form of a flat bar in said groove and fixedly attached to the shank, said cutter blade having a flat leading face with a leading blade edge in a direction of advance during use,

wherein the ~~cutter~~ blade has a leading blade edge with at least a portion of the leading edge substantially parallel to said longitudinal axis and the flat bar and is provided with a non-cutting blade edge on the leading face; and

wherein said leading blade edge is at a right angle to the flat leading face; and

machining a chipless material with the shank-end tool to provide a finished form.

22. (Currently amended). A method for the milling-type machining of chipless materials in accord with claim 21, wherein the flat leading face of the ~~cutter~~ blade is more wear resistant than the rear side of the cutter blade, wherein the ~~cutter~~ blade comprises a steel base material and is provided with a wear - protective covering on the leading flat face, the wear-protective covering being a material selected from the group consisting of a hard substance, a metal composite containing hard substances, and a metal alloy containing a hard substance.

23. (Currently amended). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the ~~cutter~~ blade further comprises a trailing edge behind the leading blade edge when viewed in the direction of advance, wherein the blade edge and the trailing edge are rounded.

24. (Currently amended). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the flat leading face of the cutter-blade has a rounded corner or a corner cut at an angle.

25. (Currently amended). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the flat leading face of the cutter-blade has an outer contour with a circular arc or conical shape.

26. (Currently amended). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the cutter-blade further comprises a curved surface having a convex face or a bent surface, parallel to the longitudinal axis, with the convex face of the curved surface or of the bend pointing in a direction of rotation of the shank in use.

27. (Currently amended). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the cutter-blade further comprises shovel-like blade folds that are sloped with a blade angle relative to the longitudinal axis to produce fan-like action.

28. (Currently amended). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the cutter-blade comprises a material selected from the group consisting of a metal, a high-strength elastically deformable material, and a springy material.

29. (Canceled).

30. (Previously presented). A method for the milling-type machining of chipless materials in accord with Claim 21, wherein the shank comprises a tubular or cylindrical hollow body at least at the second end.